

Date: Monday, 3/26/2007 3:18:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 31464	
Estimate Number : 11471	
P.O. Number : NIA	Part Number : D3140101
This Issue : 3/26/2007 S.O. No. : NIA	Drawing Number : D3140REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 27342	Material : NIA
Written By : _____	Due Date : 4/30/2007 Qty: 4 Um: Each
Checked & Approved By : <u>07.03.27</u>	
Comment : Est. A 02.04.30 New Issue NG	
Est. B 06.04.18 New dwg rev. ecn781 EC	
Est. rev.C added scuffing NCR 061 EC	
Est Rev:D As per ECN #829 06-11-20 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S032

2024-T3 .032 sheet



Comment: Qty.: 0.0466 sf(s)/Unit Total : 0.1865 sf(s)
 2024-T3 .032 sheet
 Matl: 2024-T3 (QQ-A-250/4) .032" thick
 (M2024T3S.032)

Batch **M102942****SAD****07/06/13****(4)**

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3140
 Dwg Rev: **F**
 Prog Rev: **F**

2-Deburr if necessary

SAD**07/06/13****(4)**

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD**07/06/13****(4)**

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SAD**07/06/13****(4)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:18:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31464

Part Number: D3140101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

ml 02/02/24 x4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 02/01/26 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

02/11/26 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5774*

02/11/26 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

02/01/26 (4)

Job Completion



W 02.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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31464

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

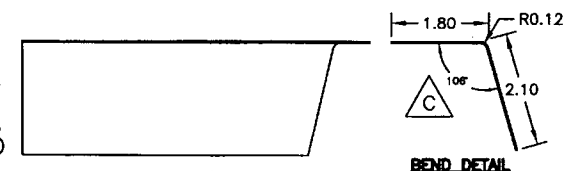
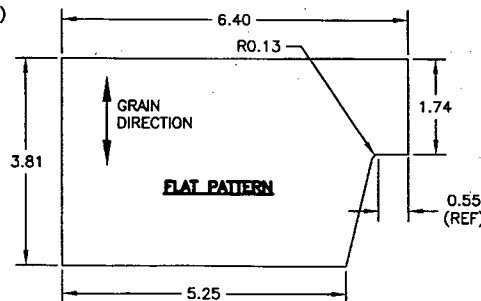
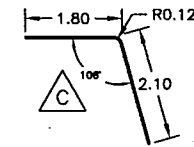
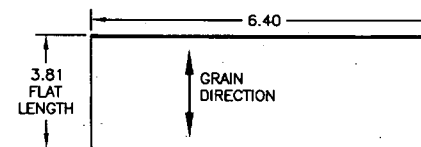
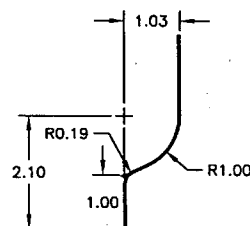
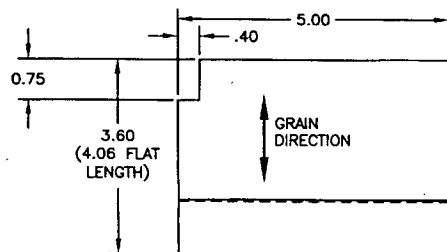
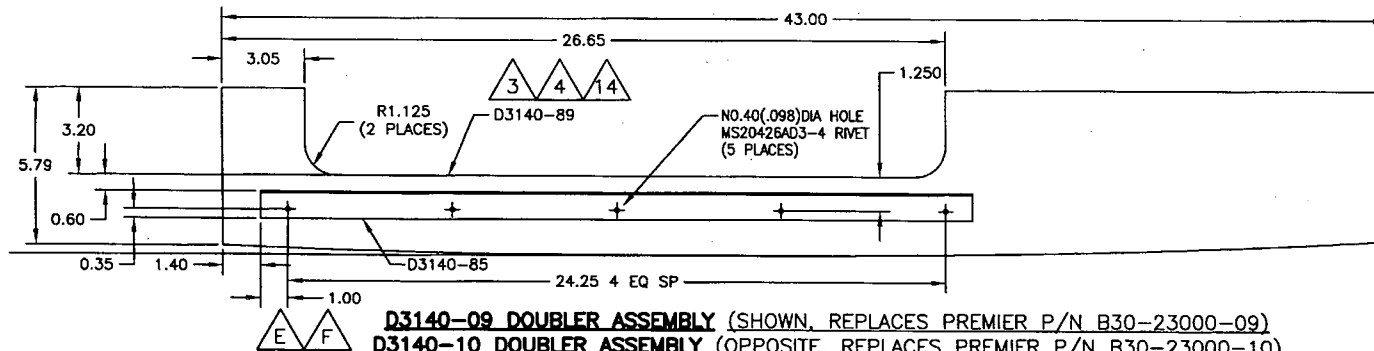
PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

F

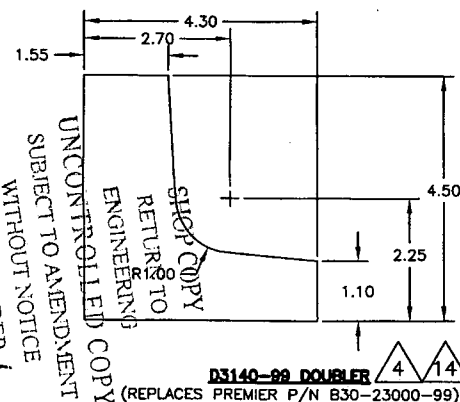
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D3140-97 DOUBLER (4/14)
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

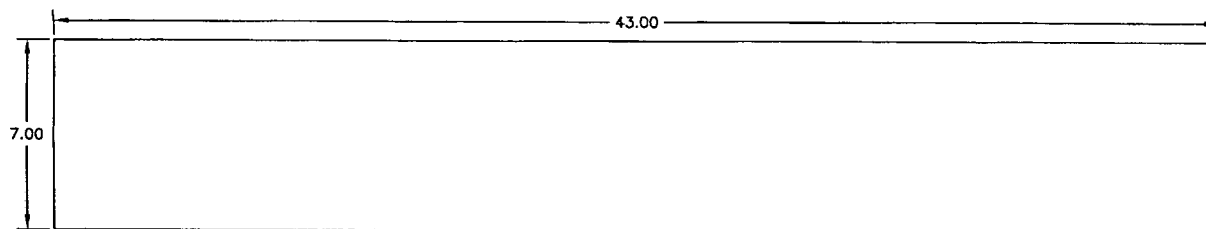




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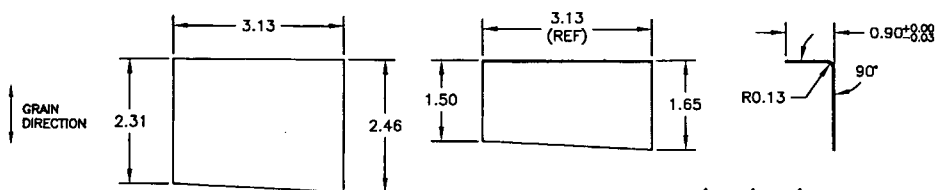
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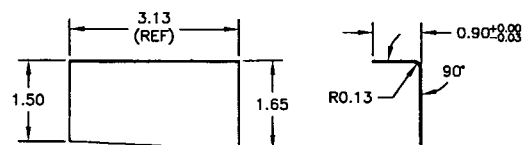
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CHECKED JH	APPROVED JH	DRAWING NO. D3140	SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	



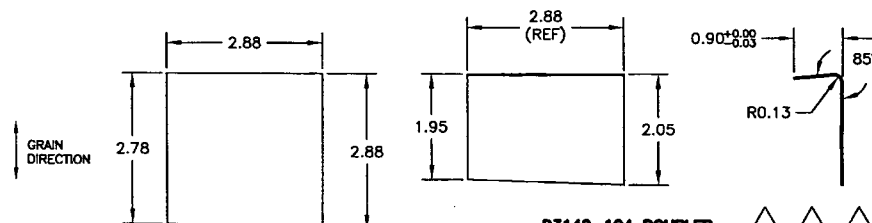
D3140-87 DOUBLER  
(REPLACES PREMIER P/N B30-23000-87)



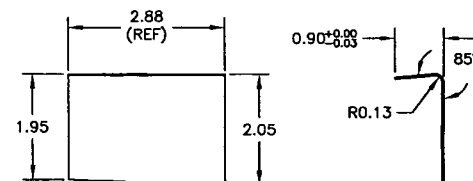
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(USED TO MAKE D3140-105/-106 BRACKETS)



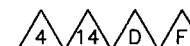
D3140-105 DOUBLER
D3140-106 OPPOSITE



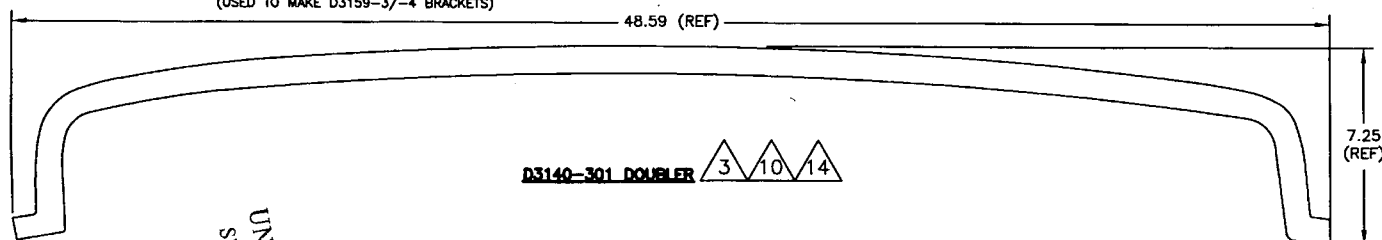
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



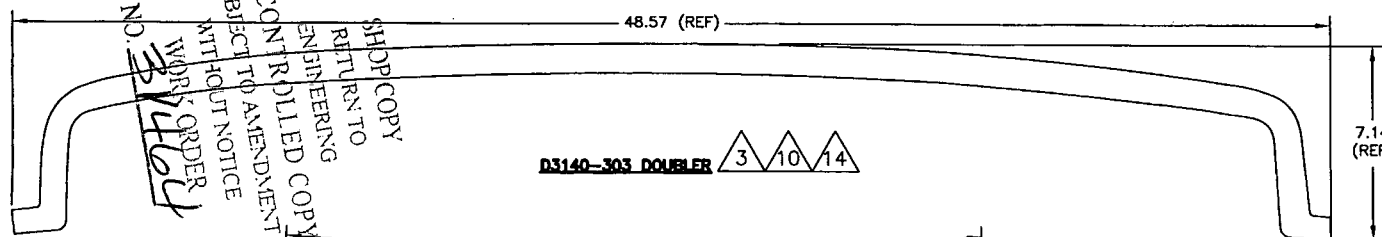
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D3140-103 OPPOSITE



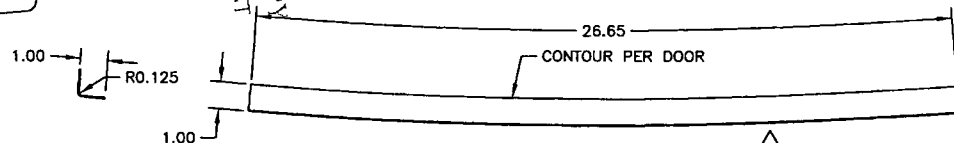
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)




D3140-301 DOUBLER   



D3140-303 DOUBLER   



D3140-85 ANGLE 
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

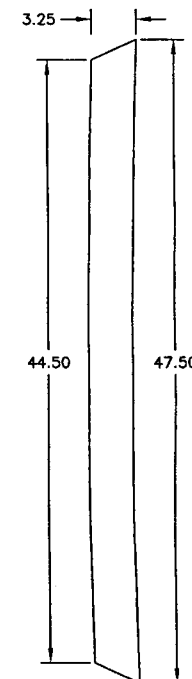
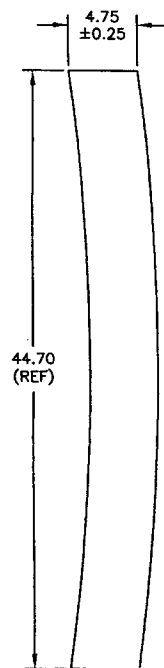
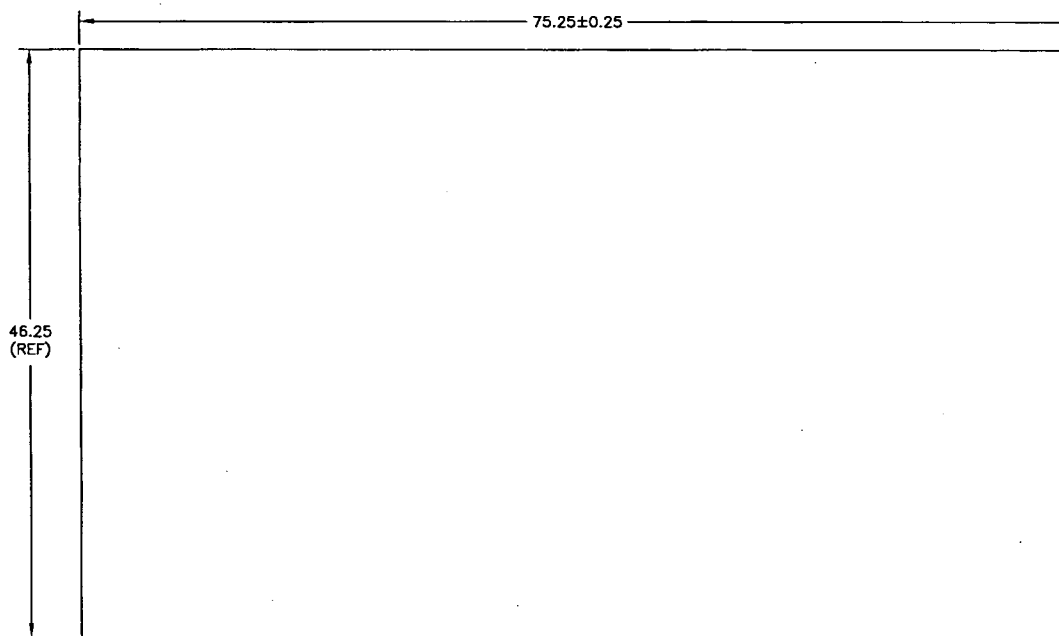
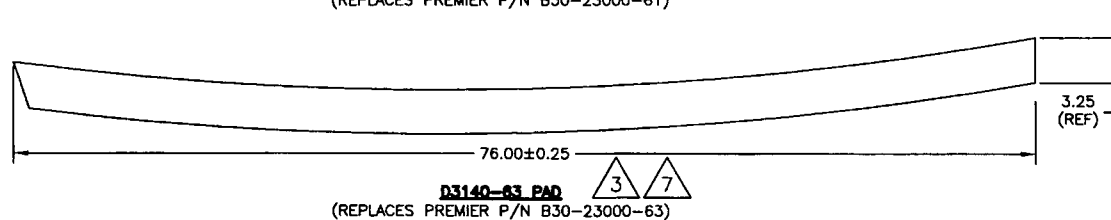
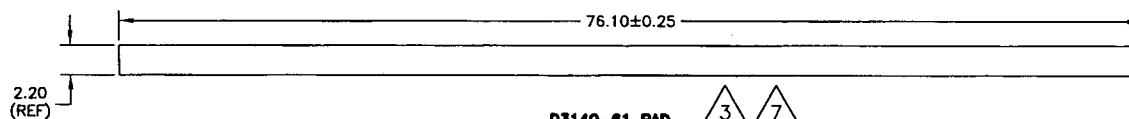
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CHECKED		APPROVED		DRAWING NO.	D3140
DATE	06.10.06	TITLE	DOOR	REV. F	SHEET 6 OF 7
		SCALE	NTS		



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

RELEASED

06.11.13

R1.00
(2 PLACES, REF)

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				TITLE	SCALE
				DOOR	NTS

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DART AEROSPACE LTD		Work Order: 31464
Description: Doobler		Part Number: D3140101
Inspection Dwg: D3140 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.20	+/- 0.030	2.198	✓		Vern	
B 2.80	+/- 0.030	2.80	✓		Vern	
C 2.05	+/- 0.030	2.05	✓		Vern	
D 0.032	+/- 0.010	0.033	✓		Vern	
E						
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X						
Y						

Measured by: SAD	Audited by: En	Prototype Approval:	N/A
Date: 07/06/13	Date: 07/06/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	